

Work Order ID 158811

Friday, March 31, 2017 7:15:38 PM

158811

Page 1

Item ID: D3209-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket Assembly
Start Date: 4/4/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/14/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED
Approvals: Process Plan: _____ Date: MAR 31 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3209	Rev A								

100 0.00
100 BAND SAW
Bandsaw Memo 0.05
Jeaspa Bandsaw Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

6

P17-04-07

110 1.06
110 HAAS CNC VERTICAL MACHINING #1
HAAS 1 Memo 1.96
HAAS CNC vertical machine #1 Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1
Deburr and Tumble

6

P17-04-15

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.06
Quality Control

6

P17-04-15

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Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.12				6	0		Stamp 49 9-89 17/04/17
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.50				6	0		20170418 BE B.
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 136370 Memo Note: Cover the hole for D3209-1 before powder coat. START TIME: 8:40 OVEN TEMPERATURE: FINISH TIME: 9:10	0.00 0.43				6	0	17-04-26	Stamp 338

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DAS
38
9-89

APR 26 2017

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Required Date: 4/14/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180 Packaging	 Memo	0.06							
Packaging	LOCATION : GA								
190	QC21- Final Inspection - Work Order Release	0.00							
190 QC	Memo	0.60							
Quality Control									

17/4/27  ~~APR 26 2017~~

DAS
21
9-89
APR 27 2017

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D3209-041

Required Date: 4/14/2017

Required Qty: 6.00

[illegible]

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST026	13	
144662	13	

M6061T6B1.500X01.25	Purchased	No
0		

M6061T6R1 500X01 250

6061-T6 Bar 1.50 x 1.25

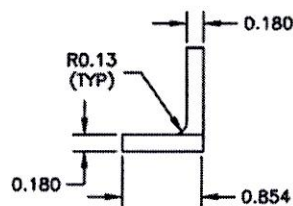
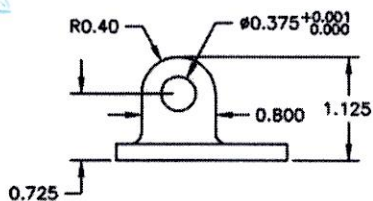
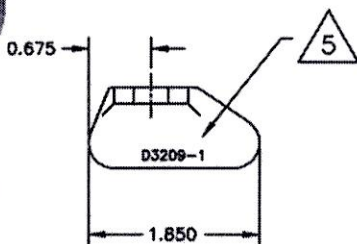
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT002	12	
m136882	12	
MAT003	4.4	
m135987	4.4	



DESIGN <i>TF</i>	DRAWN BY <i>TF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TF</i>	APPROVED <i>TF</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

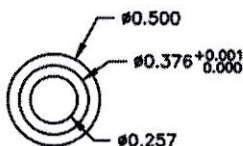
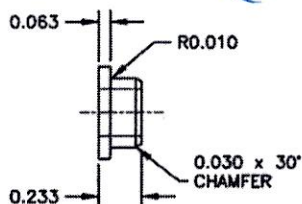
RELEASED
04.04.05

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15841



2

D3209-1 BRACKET



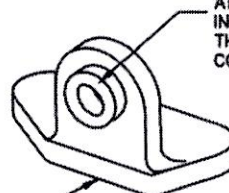
3

**D3209-3 BUSHING
SCALE 1:2**

4

D3209-041 ASSEMBLY

D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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